

Date: Wednesday, 22/04/2009 11:40:33 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW ASSEMBLY R22
Job Number : 47368A	
Estimate Number : 10789	
P.O. Number :	Part Number : D022734041
This Issue : 22/04/2009 S.O. No. :	Drawing Number : D3380 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : R & D LG FAB	Drawing Revision : B
Previous Run : 47367A	Material :
Written By :	Due Date : 15/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09-04-22</u>	
Comment : Est Rev:B 05.08.19 Revised per CHG002 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Note: If D022-734-041 is a W/O on it's own,

Copy bluefiles and create labels per PPP D022-734-041

CHG002

N/A

2.0	D33571	Wheel Shaft
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3357-1 Wheel Shaft B25167

Cpl 09-04-29

3.0	D33573	Lock Shaft
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3357-3 Lock Shaft B25168

Cpl 09-04-29

4.0	D33591	Spacer
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3359-1 Washer B22552

Cpl 09-04-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 47368A

Part Number: D022734041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 5.0	D3379041	Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3379-041

Arm Weldment

~~B22353~~
B23006

Pl09.04.29

✓ 6.0	D33801	Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3380-1

Handle

~~B23506~~
B22353

Pl09.04.29

✓ 7.0	D33811	Handle Label
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3381-1

Label

B29494

Pl09.04.29

✓ 8.0	D3399041	Wheel Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3399-041

Wheel Assembly

B29916

Pl09.04.29

✓ 9.0	GP1R	Black Vinyl Grip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 GP-1R

Black Vinyl Grip

M16871

Pl09.04.29

W/O:		WORK ORDER CHANGES					
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Drawing Name: GHW ASSEMBLY R22

Job Number: 47368A

Part Number: D022734041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 10.0

VA1140

Snap Button



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 VA-1140

Snap Button

M16372

pl09-04-29

✓ 11.0

159016

3/4"-16 UNF Thick Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 159-016

3/4"-16 UNF Thick Nut,Span

M16905

pl09-04-29

12.0

178039

1/2"-20UNF Nylon Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 178-039

1/2"-20 UNF Thin Nylon Lock Nut,Span

M16905

pl09-04-29

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per Dwg D3380

A/R

262 Locktite

M110005

pl09-04-29

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/29 @

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

** 47367*

mf 09-04-29

W/O:		WORK ORDER CHANGES					
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Job Number: 47368A

Part Number: D022734041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/30
JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

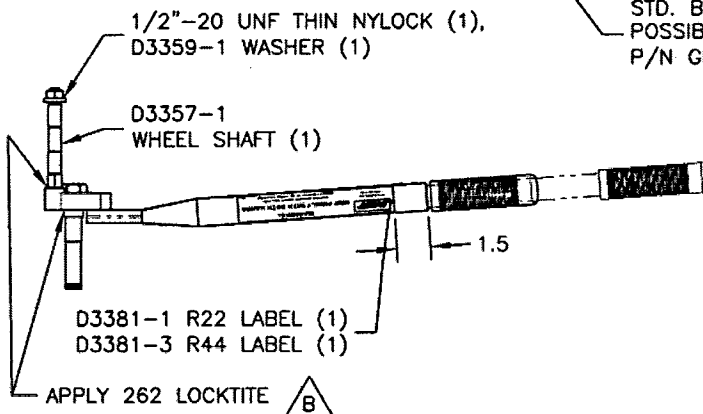
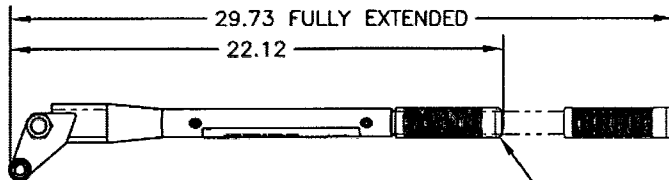
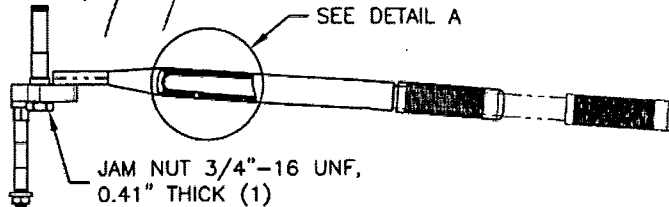
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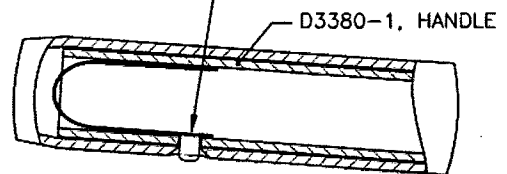
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3380	REV. B SHEET 1 OF 2
DATE 05.07.21		TITLE GROUND HANDLING ASS'Y	SCALE 1:8
A	04.12.13	NEW ISSUE	
B	05.07.21	ADD LOCKTITE	

RELEASED
05/08/15



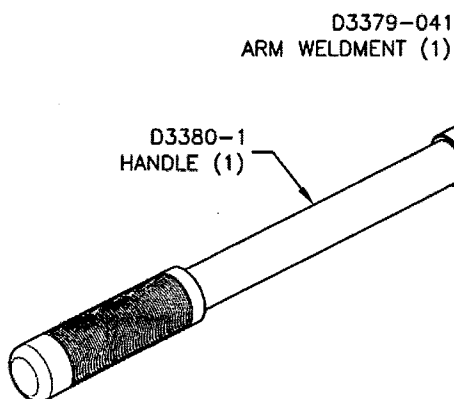
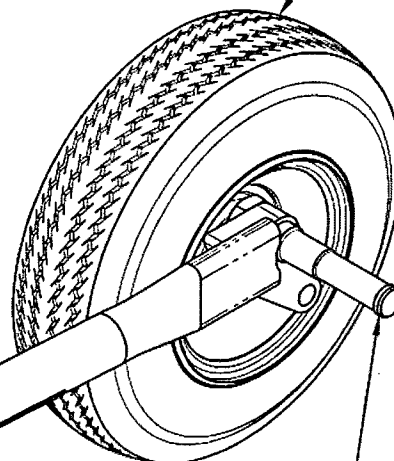
0.300 SNAP BUTTON,
POSSIBLE SUPPLIER:
REID TOOLS SUPPLY CO.,
P/N VA-1140.
INSTALL BUTTON TO
HANDLE D3380-1.



DETAIL A
SCALE 1:2

STD. BLACK VINYL GRIP, 1.000 I.D. x 4.75 LONG
POSSIBLE SUPPLIER, REID TOOLS SUPPLY CO.
P/N GP-1R (1)

D3399-041
WHEEL ASS'Y (1)



ISOMETRIC VIEW
SCALE 1:4

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

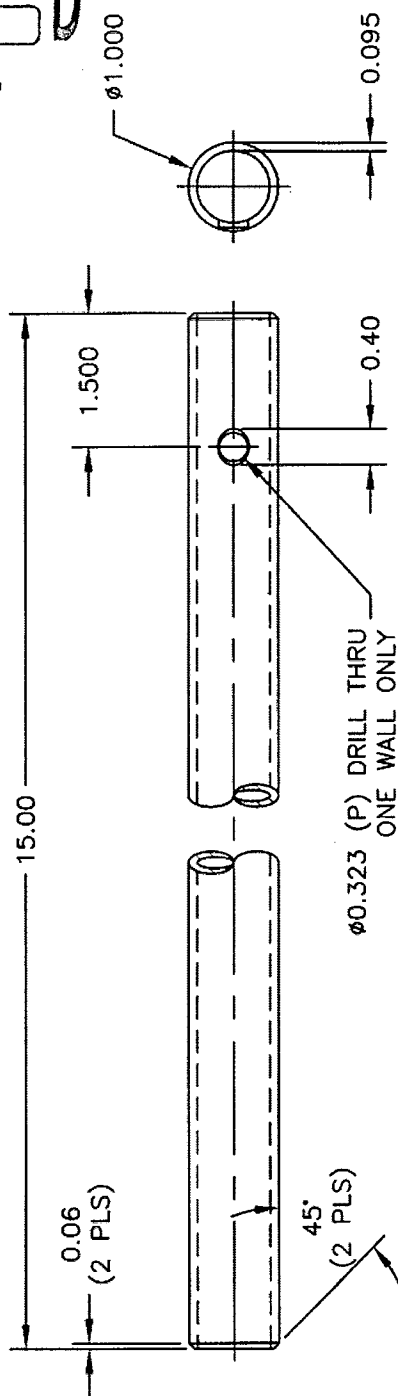
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NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3380	REV. B SHEET 2 OF 2
DATE 05.07.21		TITLE GROUND HANDLING ASS'Y	SCALE 1:2

RELEASED
[Signature]
05/08/15



D3380-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.000)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 0005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47358A

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